

Work Order ID 58859



Wednesday, May 19, 2010 3:22:24 PM

Page 1

Item ID: D407-649-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Hardpoint (6)

Start Date: 5/19/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 5/26/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 10-5-19

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

N/A

Rev N/A

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy blue file D407-649 and type labels per QSI 014

CHG001

8/10/06/16

10-6-16

110

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

10-6-16

120

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

8/10/06/16

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D407-649-011

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Item Name: Hardpoint (6)

Start Date: 5/19/2010 Start Qty: 1.00

Required Date: 5/26/2010 Req'd Qty: 1.00

Cust Item ID:



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D407-649-011								
	Location: _____								
	Rev: _____								
140		0.00							
	QC21- Final Inspection - Work Order Release								
QC	Memo	0.00							
Quality Control									

10/06/10

CMF

10-6-16

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Picklist Print

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Work Order ID: 58859

Parent Item: D407-649-011

Parent Item Name: Hardpoint (6)

Comments: IPP Rev:B 98.12.07 Changed location for step 2 DM

Start Date: 5/19/2010

Required Date: 5/26/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
80-007-15-4A Insert		Purchased	No			120	Each	17.0000	24	15X		6X
M1167003 M114794												

Location Loc Qty Loc Code

ST379 17

112086 17

AN4-6A

Purchased

No

120

Each

950.0000

24

Bolt

Location Loc Qty Loc Code

ST356 950

112933 96

113149 600

114523 54

114615 200

AN960JD416

Purchased

No

120

Each

0.0000

24

Washer

D2713

Manufactured

No

120

Each

22.0000

4

Lug

Location Loc Qty Loc Code

ST479 22

36699 22

D2755-1

Manufactured

No

120

Each

7.0000

1

Lug

Location Loc Qty Loc Code

ST479 7

17551 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Parent Item: D407-649-011



Parent Item Name: Hardpoint (6)

Start Date: 5/19/2010

Required Date: 5/26/2010

Comments: IPP Rev:B098.12.07 Changed location for step 2 DM

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
D2755-2 Lug		Manufactured	No			120	Each	18.0000	1			



10-6-16 SP

Location	Loc Qty	Loc Code
ST479	18	
14075	4	
17552	4	
48383	10	

D2756

Inner Doubler

Manufactured No

120

Each

23.0000

6



10-6-16 SP

Location	Loc Qty	Loc Code
ST024	23	
9234	23	

D2757

Outer Doubler

Manufactured No

120

Each

46.0000

6



10-6-16 SP

Location	Loc Qty	Loc Code
ST024	46	
9235	46	

M7885/2-4-1

Rivet

Purchased No

120

Each

1,637.000

96



10-6-16 SP

Location	Loc Qty	Loc Code
ST393	1637	
101692	97	
110267	1540	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
M7885/3-4-2 Rivet		Purchased	No			120	Each	983.0000	126			



10-6-16 RQ SP

Location

Loc Qty

Loc Code

ST393

983

110267

983

126

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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REFERENCE ONLY

6 PARTS LIST

Qty	Part Number	Description
X	D407-649-011	407 HARDPOINT KIT INSTALLATION
4	D2713	BRACKET
1	D2755-1	AFT BRACKET LH
1	D2755-2	AFT BRACKET RH
6	D2756	INNER DOUBLER
6	D2757	OUTER DOUBLER
96	M7885/2	RIVET
126	M7885/3	RIVET
24	AN4-6A	BOLT
24	AN960JD416	WASHER
24	80-007-15-4A	INSERT - DOME HEAD

7 HARDPOINT LOAD LIMITS (REFERENCE ONLY)

The maximum limit loads on the Hardpoint Kit are 500 lb vertical load and 280 lb radial horizontal load for each individual hardpoint. The radial horizontal and vertical loads may be applied simultaneously. Any equipment attached to the hardpoints **shall not exceed these loads**.

8 CARGO HOOK LIMITATIONS (REFERENCE ONLY)

Loads applied to the Dart Hardpoint Kit Installation will limit the load carrying capacity of the cargo hook according to the following Figure. When the hardpoints are loaded to their maximum capacity, outlined in section 7 of this document, the cargo hook is limited to carrying a maximum load of 1850 lb.

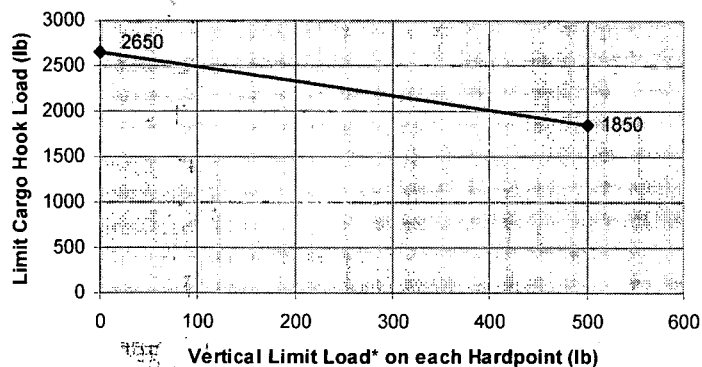


Figure 5 - Cargo Hook Limitations for Hardpoint Loads

* The Vertical Limit Load on each Hardpoint refers to the maximum allowable vertical limit load for a single hardpoint only. The 500 lb vertical limit load indicated in Figure 5 implies a maximum radial horizontal load of 280 lb, according to section 7 of this document. These limit loads should not be exceeded.

Revision : B

Date : 98.04.29

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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